

Work Order ID 120688

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120688

Page 1

Item ID: D139-816-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lightweight Interior Ceiling Panel

Start Date: 7/02/14 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 8/15/14 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals:

Process Plan: 

Date: 4-6-10

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI9686	A								
DSI9691	A								
IIN-D139-816	D								
100	Document Control	0.00							
100	DOCUMENT CONTROL								
DC	Memo	0.00							
Doc.Control -USB or Paperwork	Photocopy blue file & type labels as per PPP D139-816-011 CHG005								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

JUL 23 2014

DAS
96
9-89DAS
31
9-89DAS
93
9-89

14-07-16

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Page 2

Item ID: D139-816-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Lightweight Interior Ceiling Panel
 Start Date: 7/02/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 8/15/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC4- 100% Inspect kits for completeness	0.00							
120					DAS 31 9-89	1	1	14-08-08	
QC	Memo	0.00							
Quality Control									
130	Packaging	0.00							
130					DAS 31 9-89	1	1	14-08-08	
Packaging	Memo	0.00							
Packaging	Package as per PPP D139-816-011 Identify and Stock								
	Location: SHIP								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

4-8-8

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D139-816-011

Required Date: 8/15/14

Required Qty: 1.00

IPP Rev. C
IPP REV:D 13.12.23 AS
IPP REV E 14.04.01 AS PER

[illegible]

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Parent Item: D139-816-011

D139-816-011

Parent Item Name: Lightweight Interior Ceiling Panel

Start Date: 7/02/14

Required Date: 8/15/14

Start Qty: 1.00

Required Qty: 1.00

D4636-043 Manufactured No

110 Each 38.0000 16 16

D4636-043

Receptacle Bracket Assembly

DAS
06
9-89

Location

Loc Qty

Loc Code

ST117

38

117651

38

**

120094

DAS
32
9-89

DAS
31
9-89

D4636-11 Manufactured No

110 Each 59.0000 10 10

D4636-11

Bracket

DAS
06
9-89

Location

Loc Qty

Loc Code

ST116

59

114728

2

117652

48

92961

9

**

119837

DAS
32
9-89

DAS
31
9-89

D4636-5 Manufactured No

110 Each 51.0000 16 16

D4636-5

Bracket

DAS
06
9-89

Location

Loc Qty

Loc Code

MF3

8

111978

8

ST115

43

114660

11

116195

32

**

121038

DAS
32
9-89

DAS
31
9-89

D4636-7 Manufactured No

110 Each 24.0000 4 4

D4636-7

Retainer Plate

DAS
06
9-89

Location

Loc Qty

Loc Code

ST112

24

119838

24

**

116082

DAS
32
9-89

DAS
31
9-89

①

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Work Order ID: 120688

Parent Item: D139-816-011

Parent Item Name: Lightweight Interior Ceiling Panel

120688

D139-816-011

Start Date: 7/02/14

Required Date: 8/15/14

Start Qty: 1.00

Required Qty: 1.00

D4636-9

Manufactured No

110

Each

19.0000

1

1

D4636-9

Template

DAS
06
9-89

Location

Loc Qty

Loc Code

ST115

1

111233

1

ST116

18

117653

18

**

DAS
32
9-89

DAS
31
9-89

D4648-1

Manufactured No

110

Each

1.0000

1

1

D4648-1

Template

DAS
06
9-89

Location

Loc Qty

Loc Code

ST133

1

113950

1

**

DAS
32
9-89

DAS
31
9-89

D4653-041

Manufactured No

110

Each

6.0000

6

6

D4653-041

Vent Manifold Assembly

DAS
06
9-89

Location

Loc Qty

Loc Code

ST117

6

114705

6

**

DAS
32
9-89

DAS
31
9-89

D4653-11

Manufactured No

110

Each

98.0000

6

6

D4653-11

Clamp

DAS
06
9-89

Location

Loc Qty

Loc Code

st113

30

117661

30

ST118

68

111998

6

119841

62

**

DAS
32
9-89

DAS
31
9-89

14/11/14 (1)

119841

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Parent Item: D139-816-011

D139-816-011

Parent Item Name: Lightweight Interior Ceiling Panel

Start Date: 7/02/14

Required Date: 8/15/14

Start Qty: 1.00

Required Qty: 1.00

D4664-7

Manufactured No

110

Each

72.0000

3

3

D4664-7

Spacer

DAS
06
9-89

**

DAS
33
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

ST118

72

107035

1

111835

31

114887

40

111835

D4712-043

Manufactured No

110

Each

41.0000

2

2

D4712-043

Bracket Assembly

DAS
06
9-89

**

DAS
33
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

ST113

17

114715

17

ST118

24

119847

24

114715

D4716-1

Manufactured No

110

Each

16.0000

2

2

D4716-1

Duct Hose

DAS
06
9-89

**

DAS
32
9-89

14-07-16

Location

Loc Qty

Loc Code

ST139

2

93111

2

ST139i

2

113888

2

ST146

12

114843

12

114843

DAS
31
9-89

Picklist Print

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Work Order ID: 120688

120688

Parent Item: D139-816-011

D139-816-011

Parent Item Name: Lightweight Interior Ceiling Panel

Start Date: 7/02/14

Required Date: 8/15/14

Start Qty: 1.00

Required Qty: 1.00

D4716-3

Manufactured No

110

Each

28.0000

4

4

DAS
33
9-89

D4716-3

Duct Hose

**

119723

DAS
31
9-89

DAS
06
9-89

Location

Loc Qty

Loc Code

st139g

4

113889

4

ST146

24

114844

24

D4716-5

Manufactured No

110

Each

48.0000

6

6

DAS
33
9-89

D4716-5

Duct Hose

**

DAS
31
9-89

DAS
06
9-89

Location

Loc Qty

Loc Code

ST139

6

111289

6

st139h

12

113890

12

ST146

30

114845

30

D4728-057

Manufactured No

110

Each

10.0000

1

1

DAS
33
9-89

D4728-057

Ps7J1 Jumper

**

116305

DAS
33
9-89

DAS
06
9-89

Location

Loc Qty

Loc Code

MF

5

116304

5

MF5

5

111210

1

116306

4

DAS
31
9-89

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Work Order ID: 120688

Parent Item: D139-816-011

Parent Item Name: Lightweight Interior Ceiling Panel

120688

D139-816-011

Start Date: 7/02/14

Required Date: 8/15/14

Start Qty: 1.00

Required Qty: 1.00

D4728-063

Manufactured No

110

Each

5.0000

1 1

DAS

D4728-063

Cabin Temp Sensor Jumper Assembly

**

33
9-89

DAS
31
9-89

DAS
06
9-89

Location

Loc Qty

Loc Code

MF5

5

111217

1

116313

4

~~116313~~
116318

D4730-020-035

Manufactured No

110

Each

139.0000

24 24

D4730-020-035

Velcro Strip 2.0W/ X 3.5L

**

DAS
33
9-89

DAS
31
9-89

DAS
06
9-89

Location

Loc Qty

Loc Code

ST121

90

110415

18

114738

1

119193

71

ST122

49

111390

4

120063

45

11/12/683
13.12/682

D5032-1

Manufactured No

110

Each

68.0000

16 16

D5032-1

Doubler

**

DAS
33
9-89

121025 14-07-16

DAS
06
9-89

Location

Loc Qty

Loc Code

ST129

61

111811

1

119834

60

ST130

7

111976

7

DAS
31
9-89

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Parent Item: D139-816-011

Parent Item Name: Lightweight Interior Ceiling Panel

120688

D139-816-011

Start Date: 7/02/14

Required Date: 8/15/14

Start Qty: 1.00

Required Qty: 1.00

D5032-3

Manufactured No

110 Each

85.0000

16 16

D5032-3

Doubler

**

120970

8

DAS
06
9-89

Location

Loc Qty

Loc Code

ST129

73

119835

73

ST131

12

116584

12

2351-20-21-C3C

Purchased No

110 Each

510.0000

16 16

2351-20-21-C3C

STUD

**

DAS
33
9-89

DAS
31
9-89

DAS
06
9-89

Location

Loc Qty

Loc Code

ST396

510

M127922

72

M128068

438

50-009-2

Purchased No

100 Each

550.0000

16 16

50-009-2

Grommet

**

128068

440716

DAS
06
9-89

Location

Loc Qty

Loc Code

MF5

24

m128022

24

ST378

526

122594

1

m128022

9

m128047

516

DAS
33
9-89

DAS
31
9-89

128047

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Work Order ID: 120688

Parent Item: D139-816-011

Parent Item Name: Lightweight Interior Ceiling Panel

120688

D139-816-011

Start Date: 7/02/14

Required Date: 8/15/14

Start Qty: 1.00

Required Qty: 1.00

MS21042L3

Purchased

No

110

Each

5,953.000

35

35

DAS

33

9-89

DAS

31

9-89

MS21042L3

Nut

DAS
06
9-89

Location

Loc Qty

Loc Code

ST314

109

108816

9

M127410

13

M127831

39

M128401

48

ST506

955

123900

955

ST509

4889

M127831

2

M128754

4887

128754

MS24694-S51

Purchased

No

110

Each

152.0000

36

36

DAS

33

9-89

DAS

31

9-89

MS24694-S51

Screw

DAS
06
9-89

Location

Loc Qty

Loc Code

ST303

152

m127432

1

m128635

151

MS27039-1-15

Purchased

No

110

Each

823.0000

21

21

DAS

33

9-89

14-07-16

MS27039-1-15

Screw

DAS
06
9-89

Location

Loc Qty

Loc Code

ST306

223

124326

223

ST506

600

m127916

600

127916

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Work Order ID: 120688

Parent Item: D139-816-011

Parent Item Name: Lightweight Interior Ceiling Panel

120688

D139-816-011

Start Date: 7/02/14

Required Date: 8/15/14

Start Qty: 1.00

Required Qty: 1.00

NAS1149D0316J

Purchased

No

110

Each

1,028.000

5

5

NAS1149D0316J

Washer

**

DAS
33
9-89

DAS
31
9-89

DAS
06
9-89

Location

Loc Qty

Loc Code

ST293

628

M127993

628

ST510a

400

M127956

400

127993

NAS1149D0332J

Purchased

No

110

Each

3,308.000

34

34

NAS1149D0332J

Washer

**

DAS
33
9-89

DAS
31
9-89

DAS
06
9-89

Location

Loc Qty

Loc Code

ST294

369

m128606

369

ST510a

2939

m128612

2939

128612

NAS1149D0663J

Purchased

No

110

Each

1,809.000

6

6

NAS1149D0663J

Washer

**/1

DAS
33
9-89

14-07-16

DAS
06
9-89

Location

Loc Qty

Loc Code

ST294

7

123265

4

M126284

3

ST510a

1802

M126334

699

M127813

35

M127916

68

M128818

1000

128818

DAS
31
9-89

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Work Order ID: 120688

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Parent Item: D139-816-011

D139-816-011

Parent Item Name: Lightweight Interior Ceiling Panel

Start Date: 7/02/14

Required Date: 8/15/14

Start Qty: 1.00

Required Qty: 1.00

CB200

Purchased

No

110

Each

23.0000

3

3

CB200

Acrylic Adhesive, 3.5G

DAS

6

9-89

**

129794

Location

Loc Qty

Loc Code

ST264

23

m129423

23

CS125-1032-8AACR

Purchased

No

110

Each

26.0000

2

2

CS125-1032-8AACR

Stud

68-6

98

SVQ

**

DAS

33

9-89

DAS

31

9-89

Location

Loc Qty

Loc Code

ST283

26

M127974

26

D5078-1

Manufactured

No

110

Each

23.0000

1

1

D5078-1

Bracket

**

14-07-16

DAS

33

9-89

Location

Loc Qty

Loc Code

ST139B

23

115477

23

115477

DAS

31

9-89

DART SERVICE INSTRUCTION

TO AMEND IIN-D139-816 REV. D OR SUBSEQUENT
AND ICA-D139-816 REV. 3 OR SUBSEQUENT

REF. TCCA STC: SH12-54
REF. FAA STC: SR03251NY
REF. EASA STC: 10045158

1.0 PURPOSE

The purpose of this Dart Service Instruction (DSI) is to provide an alternate method of installing the D139-816-011 Interior Ceiling Panel Kit for customers with newer 300 series aircraft models with split center ceiling panels.

2.0 PROCEDURE

This procedure modifies step 3.1.7 of IIN-D139-816 Rev. D.

- 2.1 Position the D4634-041/-043/-045 center panels onto the p/n E4417F01 cabin isolation mounts using $\varnothing 0.25"$ (6 mm) holes in the panels. Identify those mounts that do not align with holes in the panels. Ensure that a gap between the D4634-041/-043/-045 panels of approximately 0.050" (1.3 mm) is maintained.
- 2.2 Remove extra and non-aligning cabin isolation mounts from the ceiling. Temporarily install the removed mounts into non-align holes in the panels and paint mark the back of the E4417F01 mounts. Position the D4634-041/-043/-045 center panels onto p/n E4417F01 cabin isolation mounts. Ensure the new mount locations get marked in the cabin roof. Remove panels keeping the mounts on the panels.
- 2.3 Remove ceiling insulation from aircraft ceiling at the new marked mount locations.
- 2.4 Apply a small amount of CB 200 Click Bond adhesive to the E4417F01 cabin isolation mounts that are being relocated.
- 2.5 Reposition the ceiling panels on the ceiling pressing the E4417F01 cabin isolation mounts firmly on the ceiling and holding in position until the adhesive cures enough to remove the screws from the mount.
- 2.6 Install the necessary rivets to re-fasten the E4417F01 cabin isolation mounts to the ceiling.
- 2.7 Continue the ceiling panel installation as indicated in the IIN-D139-816.

3.0 GENERAL NOTE

- 3.1 Due to the thermoforming process variations in material thickness may occur. It is acceptable to install longer or shorter Dzus fasteners as required to accomodate this material variation.

4.0 WEIGHT & BALANCE

This DSI has a negligible effect on Weight & Balance.

5.0 PARTS LIST

For D139-816-011 & CHG 005 and later, the following parts have been added to the kits.




QTY. -011	PART NUMBER	DESCRIPTION
X	D139-816-011	INTERIOR CEILING PANEL KIT
3	CB 200	3.5g ACRYLIC ADHESIVE

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.03.24
CERT. NO.: SH12-54
ISSUE NO.: 1

A	NEW ISSUE	RF	14.03.24
REV.	DESCRIPTION		BY DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9686	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		ALTERNATE INSTALLATION	NTS
DATE	14.03.24	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

DART SERVICE INSTRUCTION

TO AMEND IIN-D139-816 REV. D OR SUBSEQUENT
AND ICA-D139-816 REV. 3 OR SUBSEQUENT

REF. TCCA STC: SH12-54

REF. FAA STC: SR03251NY

REF. EASA STC: 10045158

1.0 PURPOSE

The purpose of this Dart Service Instruction (DSI) is to provide instructions to install the D5078-1 Bracket to support the Overhead Connector for D139-811-011 Interior Ceiling Panel Kit.

2.0 PROCEDURE

This procedure is added after step 3.1.39 of IIN-D139-816 Rev. D.

- 2.1 Position the D5078-1 Bracket on the LH side of the cabin overhead by temporarily removing 2x MS27039-1 screws as shown in Figure 1. Transfer 2x $\varnothing 0.204$ " (#6 drill) holes from airframe to the D5078-1 Bracket. Deburr and touch-up holes with MIL-P-85582 or MIL-P-23377 primer.
- 2.2 Install D5078-1 Bracket using existing 2x MS27039-1 screws and washers as shown in Figure 1.
- 2.3 Install overhead cannon plug in the D5078-1 Bracket using existing NAS1801/1802 screws and existing AS85049/95-20A-A Perimeter Mounting Flange as shown in Figure 2.
- 2.4 Reconnect wire harness to overhead cannon plug as shown in Figure 2.

4.0 WEIGHT & BALANCE

This DSI has a negligible effect on Weight & Balance.

5.0 PARTS LIST

The D5078-1 bracket has been added to D139-816-011 Kits at CHG 005 and later. Customers who wish to obtain the D5078-1 Bracket for a kit that has already been installed can procure the DSI 9691-011 kit from Dart as outlined below.




QTY. -011	PART NUMBER	DESCRIPTION
X	DSI 9691-011	BRACKET KIT
1	D5078-1	BRACKET

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 14.03.24
CERT. NO.: SH12-54
ISSUE NO.: 1

A	NEW ISSUE	RF	14.03.24
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9691	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		BRACKET INSTALLATION	NTS
DATE	14.03.24	COPYRIGHT © 2014 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

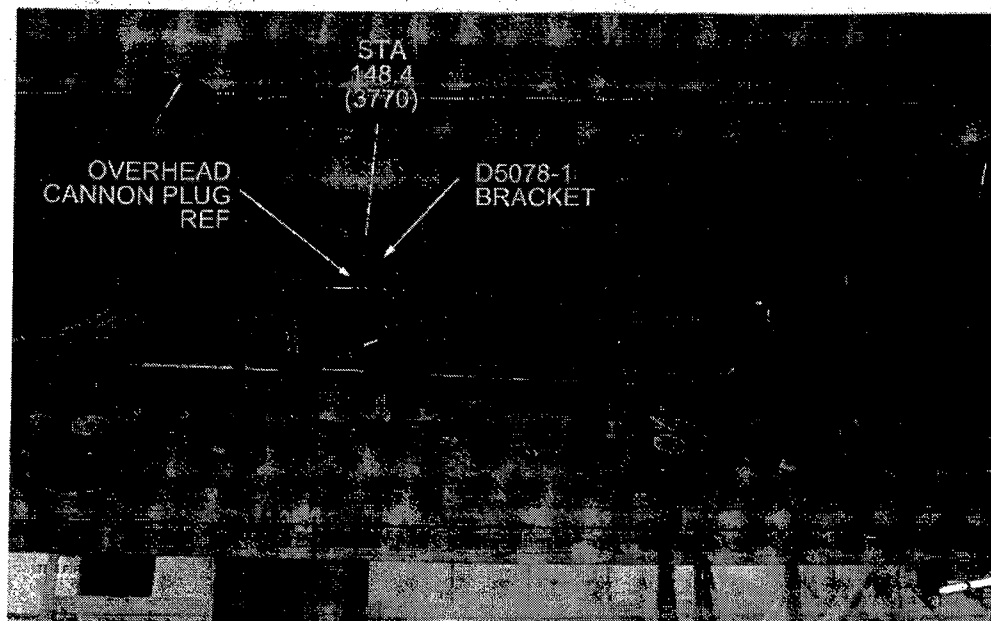


Figure 1. - LH Side Overhead Panel

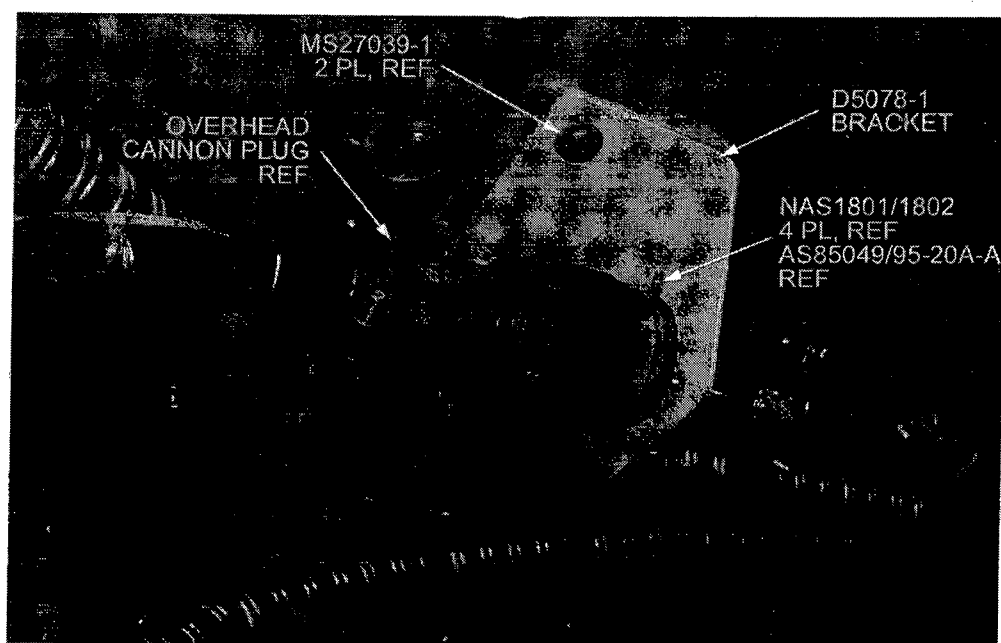


Figure 2. - D5078-1 Bracket Installation

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9691	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BRACKET INSTALLATION	NTS
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